

Work Order ID 72712

Tuesday, August 09, 2011 11:34:00 AM



ASPP

Page 1

Item ID: D4334-3

Accept



Setup Start



Revision ID:

Item Name: Base

Stop



Start Date: 8/9/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-08-09

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4334	A

120

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

MILL AS PER DWG
DWG REV: A

OK 11/08/10

3 0 0

DEBURR

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 11/08/10

3 0

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

OK 11-08-10

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4334-3

Accept

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Item Name: Base

Start Date: 8/9/2011 Start Qty: 3.00

Required Date: 8/12/2011 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

w/o
72571

EBS 11/08/11 (3)

EBS 11/08/11 (3)

W/O:		WORK ORDER CHANGES					
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Work Order ID 72712

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Item ID: D4334-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Base

Start Date: 8/9/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/11

111-08-11

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 09, 2011 11:33:53 AM

Page 1

Work Order ID: 72712



Parent Item: D4334-3



Parent Item Name: Base

Start Date: 8/9/2011

Required Date: 8/12/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 11-02-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			120	f	7.1661	0.208	0.656842			



6061-T6 Bar 1.25 x 1.25

Location

Loc Qty

Loc Code

MAT003

7.1661

117798

7.1661

656 and 11/08/09

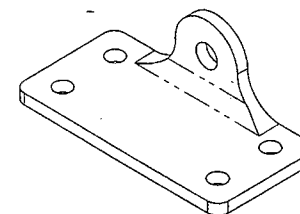
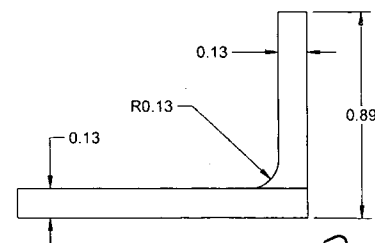
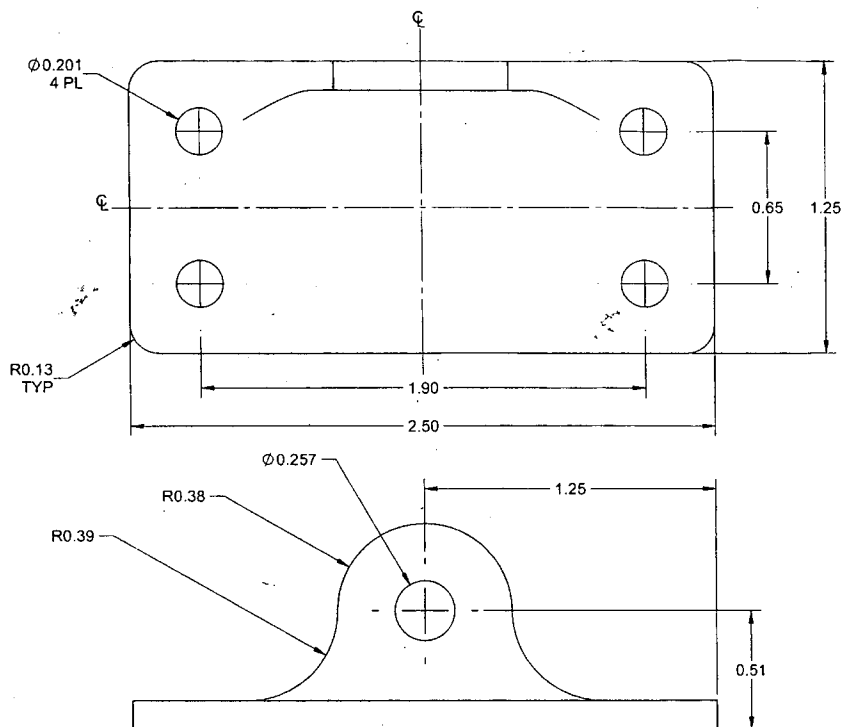
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NOTE: Date & initial all entries



D4334-3 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	45	DART AEROSPACE LTD	
DRAWN	45	HAWKESBURY, ONTARIO, CANADA	
CHECKED	45	DRAWING NO.	REV. A
MFG. APPR.	45	D4334	SHEET 5 OF 11
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
DATE	11.04.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

RELEASED
2011-05-27

72712

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 72712
Description: BASE		Part Number: D4334-3
Inspection Dwg: D4334 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.201	+ .005 - .001	Ø.203	—		Vern ML-7	
R.13	± .030	R.130	—		R-6	
2.50	± .030	2.502	—		Vern ML-7	
1.90	± .030	1.900	—		"	
1.25	± .030	1.249	—		"	
.65	± .030	.650	—		"	
1.25	± .030	1.248	—			
.51	± .030	.510	—		"	
Ø.257	+ .006 - .001	Ø.258	—		"	
R.38	± .030	R.380	—		R-6	
R.39	± .030	R.380	—		"	
.13	± .030	.132			Vern ML-7	
R.13	± .030	R.130	—		R-6	
.13	± .030	.133	—		Vern ML-7	
.89	± .030	.892	—		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval: <i>[Signature]</i>
Date: 11/08/10	Date: 11-08-10	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15